

Work Order ID 138426

Tuesday, October 27, 2015 11:28:15 AM

138426

Page 1

Item ID: 647.7401 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 10/26/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/26/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: ML3 Date: OCT 29 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7400	B

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

DAS
27
9-89

NOV 04 2015

120 0.00

120

Small Fab Memo 0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 133436
exp. date: 07/17

2X

15/11/24

DAS
36
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

(2)

DAS
38
9-89
NOV 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Work Order ID 138426***138426***

Page 2

Item ID: 647.7401

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Assembly

Start Date: 10/26/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: **KG**

0.00

2***140***

Packaging

Memo

0.00

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV*****3-03
6
9-03**

NOV 25 2015

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 15-11-25
MLJ 15-11-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY							
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Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
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Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Tuesday, October 27, 2015 11:28:14 AM

Page 1

Work Order ID: 138426

138426

Parent Item: 647.7401

647 7401

Parent Item Name: Upper Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7812 *647 7812* Center Plate, Upper		Purchased	No				Each	0.0000		2			
647.7810 *647 7810* Bracket A		Manufactured	No				Each	4.0000		2			
										DAS 36 9-89			
										15/11/23			
										B 138505 **			
										(2)			
										**			
										DAS 27 9-89			
										2			
647.7811 *647 7811* Bracket B		Manufactured	No				Each	4.0000		2			
										DAS 27 9-89			
										2			
										2			
										**			
										DAS 27 9-89			
										2			
646.3015 *646 3015* Blade		Manufactured	No				Each	7.0000		4			
										DAS 27 9-89			
										2			
										2			
										**			
										DAS 27 9-89			
										2			
647.7610 *647 7610* Upper Deflector		Manufactured	No				Each	0.0000		2			
										DAS 36 9-89			
										15/11/23			
										**			

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER :							

Picklist Print

Tuesday, October 27, 2015 11:28:15 AM

Page 2

Work Order ID: 138426

138426

Parent Item: 647.7401

647 7401

Parent Item Name: Upper Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149FN832P

Purchased

No

Each

2,160.000

136

NAS1149FN832P

Washer

**

15/11/23

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

346

125268 —

346

22

ST260a

500

M133316 —

500

114

ST267

393

125268

100

M133284

293

st268

921

M130388

921

MS27039-08-23

Purchased

No

Each

1.0000

14

MS27039-08-23

Screw

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST281

1

123348

1

m133498

NOV 0 4 2015

MS27039-08-19

Purchased

No

Each

479.0000

12

MS27039-08-19

Screw

**

15/11/23

DAS
36
9-89

Location

Loc Qty

Loc Code

cck007a

100

m133077

100

GA

186

m132930

186

12

ST273A

164

m131317

164

ST281

29

m131264

29

Tuesday, October 27, 2015 11:28:15 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

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138426

Parent Item: 647.7401

647 7401

Parent Item Name: Upper Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042-08 MS21042L08 Purchased No

Each 33.0000 26

MS21042-08

USE MS21042L08

DAS
27
9-89

Location

Loc Qty

Loc Code

ST304

25

122815

25

ST306

8

m130388

8

Each

1,509.000

12

NAS1149F0332P

Purchased

No

NAS1149F0332P

Washer

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

162

122063

162

ST260a

636

m128401

6

m131026

80

m131697

50

m133284

500

st268

117

123900

7

m130388

86

m133077

24

ST288

594

m133134

594

NOV 04 2015

15/11/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Page 4

Work Order ID: 138426

138426

Parent Item: 647.7401

647 7401

Parent Item Name: Upper Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-19

Purchased

No

Each

223.0000

6

MS27039-1-19

Screw

15/11/23

DAS
36
9-89

Location

Loc Qty

Loc Code

cck007a

200

m133134

200

GA

20

m124326

20

ST285

3

m127904

3

Each

247.0000

6

MS21042-3

MS21042L3

Purchased

No

MS21042-3

Nut / use MS21042L3

BAS
27
9-89

Location

Loc Qty

Loc Code

ST305

247

M128770

10

M129541

15

M129682

199

M130388

23

NOV 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

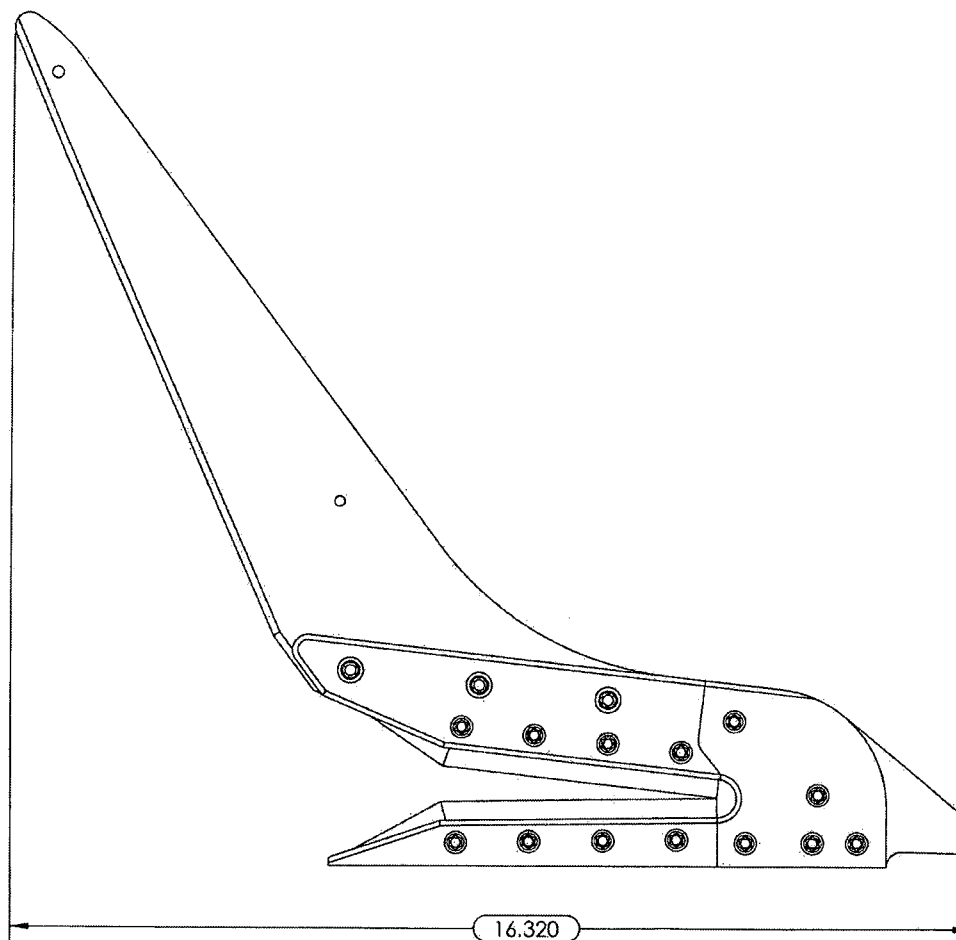
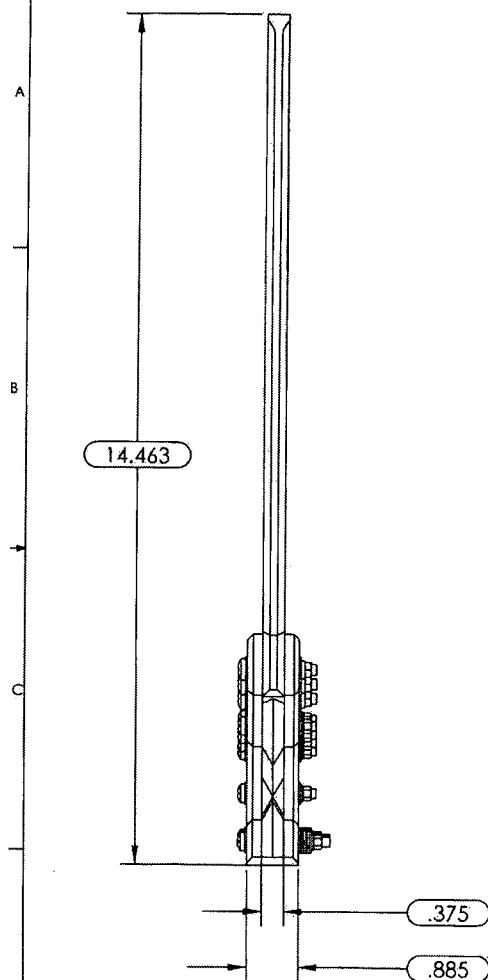
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

QTY		PARTS LIST	
NEXT ASSY (S)		APICAL INDUSTRIES	
647.7300		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
ORIGINAL DATE 11-28-89 REV. DATE 11-28-89 PARTS LIST A. CHIAN B. BRADY DRAWING APPROVAL: 12-11-89 COMMENTS:		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 4 PLACE DECIMALS ± .001		SEE CASE CODE B 07M26	DWG. NO. 647.7400
		SCALE: NONE	SHEET 1 OF 2

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ORIGINAL DATE 11-23-06		APICAL INDUSTRIES	
DRAWN BY A. GUAN		2608 TEMPLE HEIGHTS DR.	
CHECKED BY J. BRAY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAY		UPPER CUTTER ASSY	
DATE 11-21-09			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SEE CAD CODE B 07M26	REV B
		SCALE NONE	SHEET 2 OF 2

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

UPPER CUTTER ASSY

647.7400
SCALE NONE
SHEET 2 OF 2